

Work Order ID 104721

104721

Page 1

July-17-13 9:22:58 AM

Item ID: D4635-3 Accept

Revision ID:

Item Name: Aft Ceiling Panel, LH

Start Date: 7/17/13 Start Qty: 1.00 *1*

Required Date: 7/25/13 Req'd Qty: 1.00 *1*

Reference:

Approvals: Process Plan: MLJ Date: 13-07-13 Tooling:

QC: _____ Date: _____ SPC (Y/N): _____

N900040100 Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours
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Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4635	C
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100 0.00

100 HAND FINISHING THERMOFORMING

Thermoform Memo 0.00

Thermoforming Machine Cut Blanks

105 0.00

105 Dry Material

HandThermo Memo 0.00

Hand Finishing Thermoforming Dry Sheet as per QSI022 KYDEX

Temp: 150 F

Time IN: 7:00 pm 13/07/15

Time OUT: 7:00 am 13/07/16

DAS
07
2-89

13/07/16

DAS
07
2-89

13/07/16

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Page 2

Item ID: D4635-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Ceiling Panel, LH

Start Date: 7/17/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/25/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____
QC: _____ Date: _____ SPC (Y/N): _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours
110		0.00
110	THERMOFORMING MACHINE	
Thermoform	Memo	0.00
Thermoforming Machine	Thermoform as per Dwg. D4635-3 and Folio FTA149	
	Dwg. Rev. <u>C</u>	
	Folio Rev. <u>C</u>	
	Visually inspect for proper formation and texture	
130		0.00
130	HAND FINISHING THERMOFORMING	
Thermoform	Memo	0.00
Thermoforming Machine	Trim to Finished Dimensions	
140	QC2- Inspect parts off machine FAI/FAIB	0.00
140		
QC	Memo	0.00
Quality Control		

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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xL _____ D4635-3
13/07/16

xL _____ Wh
13/07/31

xL _____ Wh
13/07/31

Work Order ID 104721

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July-17-13 9:22:58 AM

Item ID: D4635-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Ceiling Panel, LH

Start Date: 7/17/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/25/13 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

13.8.7

160

Packaging

0.00

160

Packaging

Memo

0.00

Packaging

USED FOR D4635-143
B104786

x1

15/08/07

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

ML5 13-08-12

Cpl 13.8.8

3

Picklist Print

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Page 1

Work Order ID: 104721

Parent Item: D4635-3

Parent Item Name: Aft Ceiling Panel, LH

Start Date: 7/17/13

Required Date: 7/25/13

Start Qty: 1.00

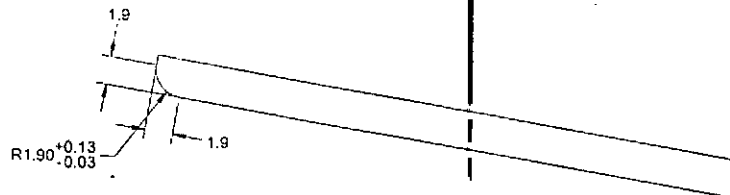
Required Qty: 1.00

Comments: IPP Rev. A New Issue 12/05/07 DL VERIFIED BY:JLM IPP Rev. B Dwg. Update
12/11/08 DL IPP Rev C Dwg. Update 13/07/09 DL

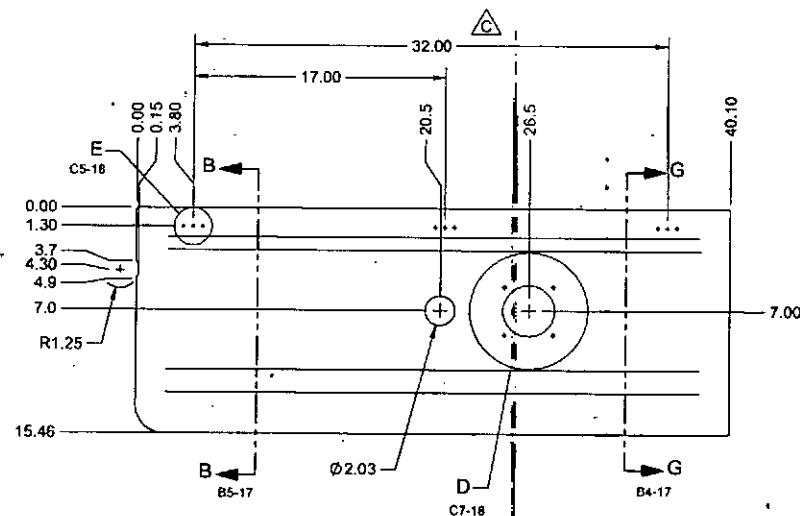
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 52068 Kydex steel grey		Purchased	No			100	sf	2,255.4554	8.49	9.4333333			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				therm		2255.455401							
				119476		120.100001							
				121902		1060.697							
				122181		1074.6584							

W/L
13/08/01

9.44 sg of



SECTION H-H B2-15



D4635-3 LH, AFT CEILING PANEL

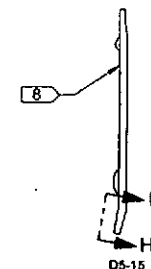
NOTES:

- 1) MATERIAL: KYDEX 6185 SHEET, 0.080 THICK,
P3-VELOUR MATTE, STEEL GRAY #52068
PER DART SPEC MKYD6185S.080-P3-52068
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.60 lbs
- 8) TEXTURE ON THIS SIDE
- 9) TRIM D4635-3 PER TOOL DT9841
- 10) THERMOFORM D4635-3 PER QSI 022 USING DT9849 TOOL
MIN. THICKNESS AFTER FORMING:
RIDGES/EDGES = 0.060
ELSEWHERE = 0.070

RET
UNCL
SUB

W
V

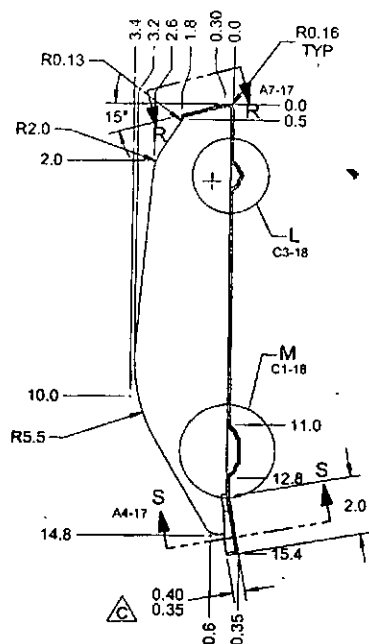
104721 MLJ
13-07-17



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2013-07-15

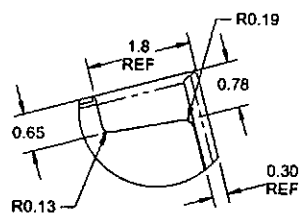
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MFG. APPR.	DL	D4635	SHEET 15 OF 18
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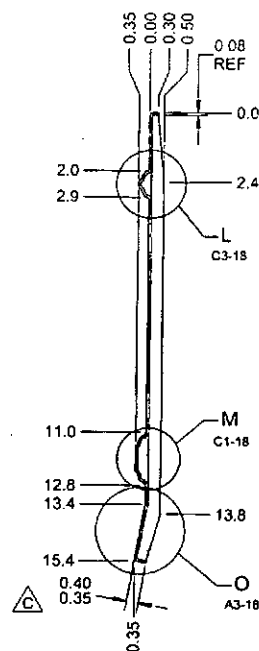
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SECTION A-A' OPPOSITE
SCALE 2X

B3-13
B3-14



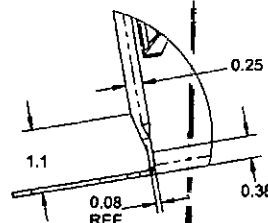
AUXILIARY VIEW R-R
SECTION R-R' OPPOSITE
SCALE 2X

D7-17



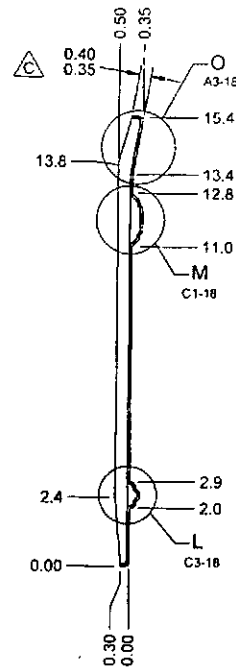
SECTION B-B
SCALE 2X

B7-13
B7-14



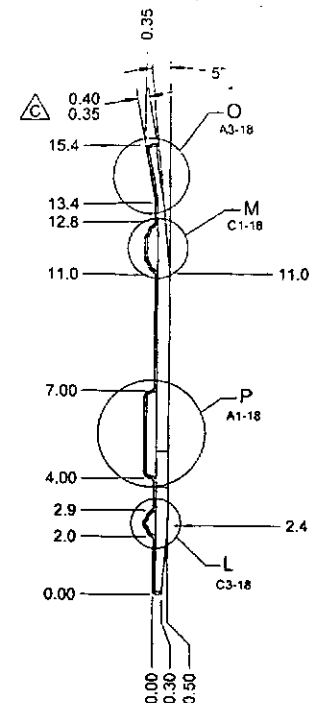
AUXILIARY VIEW S-S
SECTION S-S' OPPOSITE
SCALE 2X

B7-17



SECTION G-G
SCALE 2X

B4-15
B4-16



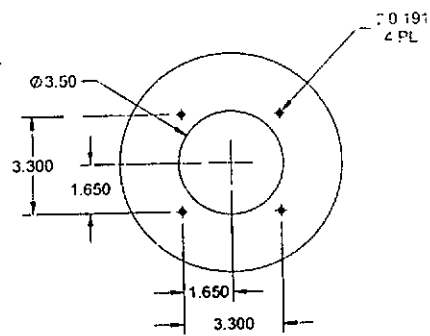
SECTION K-K
SCALE 2X

C6-16

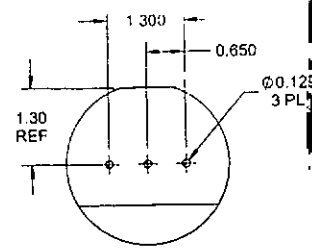
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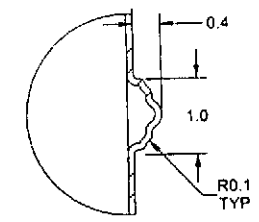
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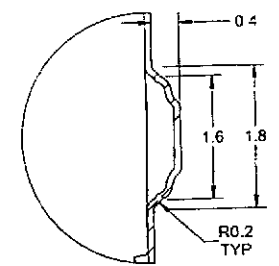
DETAIL D
SCALE 2X
B4-13
B3-14
B5-15
B5-16



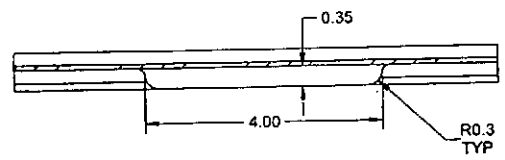
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B6-14
C6-15
B5-16



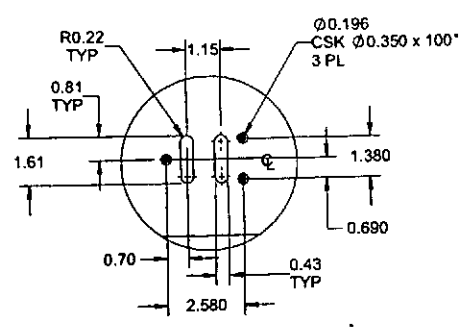
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B2-17
B4-17
C5-17
C7-17



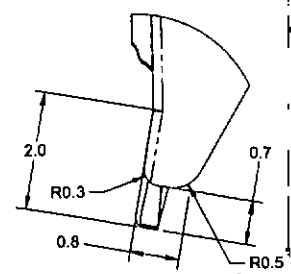
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C3-17
C5-17
C7-17



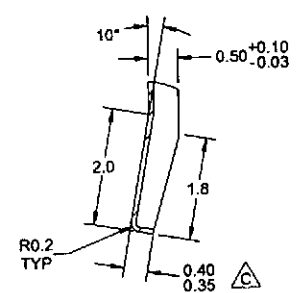
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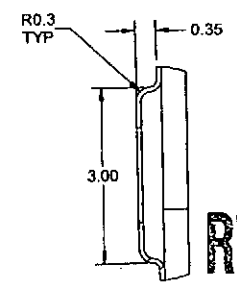
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DETAIL N
SCALE 2X
B2-13



DETAIL O
SCALE 2X
D2-17
D3-17
B5-17



DETAIL P
SCALE 4X
C2-17

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